

Work Order ID 120608

June-05-14 3:06:50 PM

*del Indry 6/6*

\*120608\*

Page 1

Item ID: D3531-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Top Mounted Gps Bracket  
 Start Date: 6/05/14 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 6/06/14 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: *W* Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D3531                          | B                        |                      |         |        |              |               |               |                  |                |

100 0.00  
**\*100\*** Small Fab  
 Small Fab Memo 0.00  
 Small Fab Transfer drill holes, Dimples sink and assemble as per dwg D3531

*2x* *14/06/05* DAS 36 9-89

110 0.00  
**\*110\*** QC5- Inspect part completeness to step on W/O  
 QC Memo 0.00  
 Quality Control

DAS 27 9-89  
*4/6/6*

*2*

120 0.00  
**\*120\*** Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  
 Powdercoat Memo 0.00  
 Powder Coating  
 START TIME: *10:40* OVEN TEMPERATURE:  
 FINISH TIME: *11:10*

*17126878*

*2* *14-6-6* DAS 34 9-89

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June-05-14 3:06:50 PM

\*120608\*

Page 2

Item ID: D3531-041 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Top Mounted Gps Bracket  
Start Date: 6/05/14 Start Qty: 2.00 \*2\* Cust Item ID:  
Required Date: 6/06/14 Req'd Qty: 2.00 \*2\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                        | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130                            | QC3- Inspect Part Finish                        | 0.00                 |         |        |              | 2             |               |                  |                |
| *130*                          |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 140                            | Identify as per dwg & Stock Location: <u>ST</u> | 0.00                 |         |        |              | 2x            |               |                  | JUN 06 2014    |
| *140*                          |   |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |   |                      |         |        |              |               |               |                  |                |
| 150                            | QC21- Final Inspection - Work Order Release     | 0.00                 |         |        |              |               |               |                  |                |
| *150*                          |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

ME  
14-6-6

June-05-14 3:06:49 PM

**\*120608\***

**\*D3531-041\***

**Required Qty: 2.00**

IPP REV:B

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty    | Qty<br>Issued | Date<br>Issued | Status            |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|-------------------|
| D3531-1                         |                        | Manufactured  | No          |                     |                  | 100             | Each               | 0.0000         | 1           | 2               |               |                |                   |
| <b>*D3531-1*</b>                |                        |               |             |                     |                  |                 |                    | B116751        | 2a          | **              |               | 14/06/05       | DAS<br>36<br>9-89 |
| Bracket                         |                        |               |             |                     |                  |                 |                    |                |             |                 |               |                |                   |
| D3531-3                         |                        | Manufactured  | No          |                     |                  | 100             | Each               | 2.0000         | 1           | 2               |               |                |                   |
| <b>*D3531-3*</b>                |                        |               |             |                     |                  |                 |                    |                | **          |                 |               | 14/06/05       | DAS<br>36<br>9-89 |
| Bracket Front Plate             |                        |               |             |                     |                  |                 |                    |                |             |                 |               |                |                   |
|                                 |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               |                |                   |
|                                 |                        |               |             | GA                  |                  |                 |                    | 2              |             |                 |               |                |                   |
|                                 |                        |               |             | 109363              |                  |                 |                    | 2              |             |                 |               |                |                   |
| MS20426AD4-4                    |                        | Purchased     | No          |                     |                  | 100             | Each               | 2,954.000      | 2           | 4               |               |                |                   |
| <b>*MS20426AD4-4*</b>           |                        |               |             |                     |                  |                 |                    |                | **          |                 |               | 14/06/05       | DAS<br>36<br>9-89 |
| Rivet                           |                        |               |             |                     |                  |                 |                    |                |             |                 |               |                |                   |
|                                 |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               |                |                   |
|                                 |                        |               |             | GA                  |                  |                 |                    | 210            |             |                 |               |                |                   |
|                                 |                        |               |             | 129090              |                  |                 |                    | 210            |             |                 |               |                |                   |
|                                 |                        |               |             | ST334               |                  |                 |                    | 2744           |             |                 |               |                |                   |
|                                 |                        |               |             | 125445              |                  |                 |                    | 2744           |             |                 |               |                |                   |

# Picklist Print

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Work Order ID: 120608

\*120608\*

Parent Item: D3531-041

\*D3531-041\*

Parent Item Name: Top Mounted Gps Bracket

Start Date: 6/05/14

Required Date: 6/06/14

Start Qty: 2.00

Required Qty: 2.00

MS20470AD4-4

Purchased

No

100

Each

2,173.000

10

20

**\*MS20470AD4-4\***

\*\*

14/06/05

DAS  
36

Rivet, Universal Head

Location

Loc Qty

Loc Code

GA

180

121652

180

ST336

27

118614

27

ST553

1736

M128401

1736

ST563

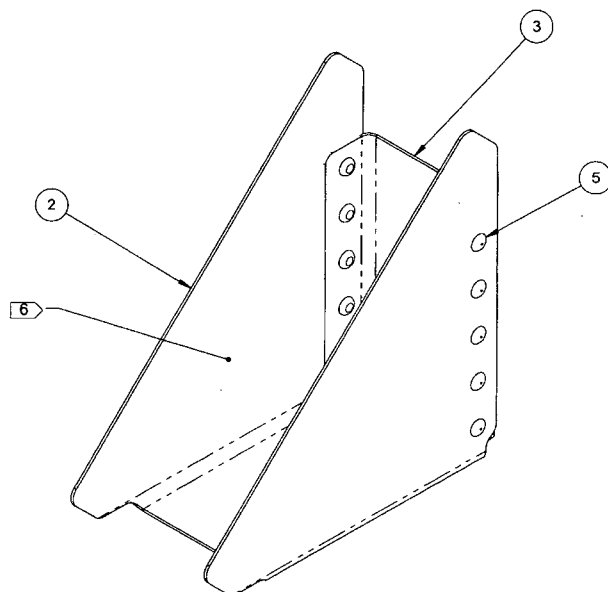
230

M128754

230

20

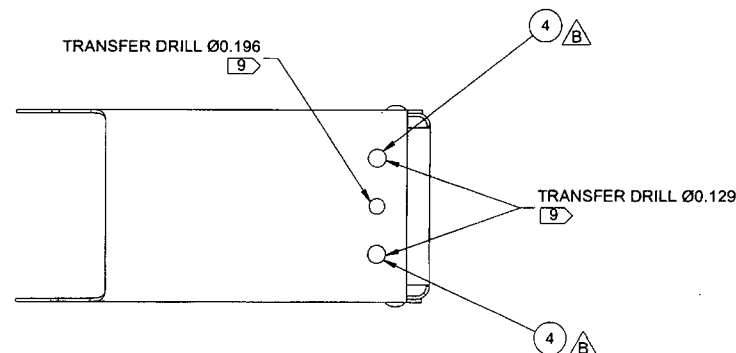
| ITEM NO. | QTY.<br>-041 | PART NUMBER  | DESCRIPTION         |
|----------|--------------|--------------|---------------------|
| 1        | X            | D3531-041    | BRACKET ASSEMBLY    |
| 2        | 1            | D3531-1      | BRACKET             |
| 3        | 1            | D3531-3      | BRACKET FRONT PLATE |
| 4        | 2            | MS20426AD4-4 | RIVET               |
| 5        | 10           | MS20470AD4-4 | RIVET               |



**D3531-041 BRACKET ASSEMBLY**

**NOTES:**

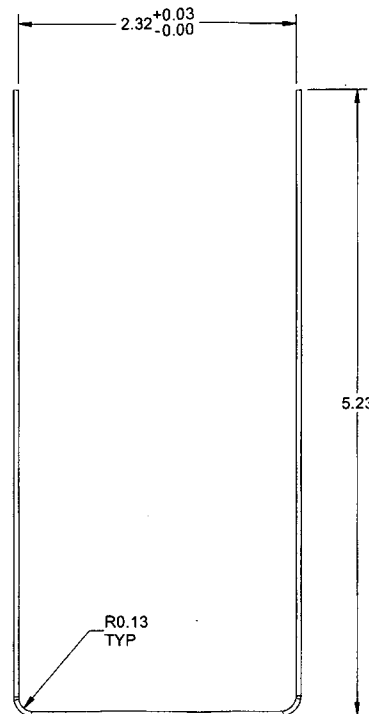
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON INSIDE OF BRACKET ASSEMBLY, WHERE INDICATED
- 7) WEIGHT: 0.22 lbs
- 8) ASSEMBLE PER DART QSI 003
- 9) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE BEFORE FINISHING



**D3531-041 BRACKET ASSEMBLY  
BOTTOM VIEW**

**RELEASED**  
12/10/13 9:11  
PER ECN 12-669

| B   | CHANGE BOTTOM RIVETS FROM MS20470AD4-4 TO MS20426AD4-4, ZN C2-1, C5-3. ADD CSK, ZN C5-3. CORRECT BEND LINE DIM, ZN C4-3. UPDATE TO CURRENT DWG STANDARDS, REF PAR 10-47. | DC | 12.08.09 |
|---|--|----|----------|
| A   | NEW ISSUE  | CB | 07.06.19 |
| REV.  | DESCRIPTION  | BY | DATE     |
| DESIGN  | CB   |    |          |
| DRAWN   | BC   |    |          |
| CHECKED   | BE   |    |          |
| MFG. APPR.  | AP   |    |          |
| APPROVED  | AP   |    |          |
| DE APPR.  | AP   |    |          |
| DATE  | 12.08.09   |    |          |
| <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br>DRAWING NO. <b>D3531</b><br><b>BRACKET ASSEMBLY</b><br>SCALE <b>NTS</b><br><small>COPYRIGHT © 2012 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |  |    |          |



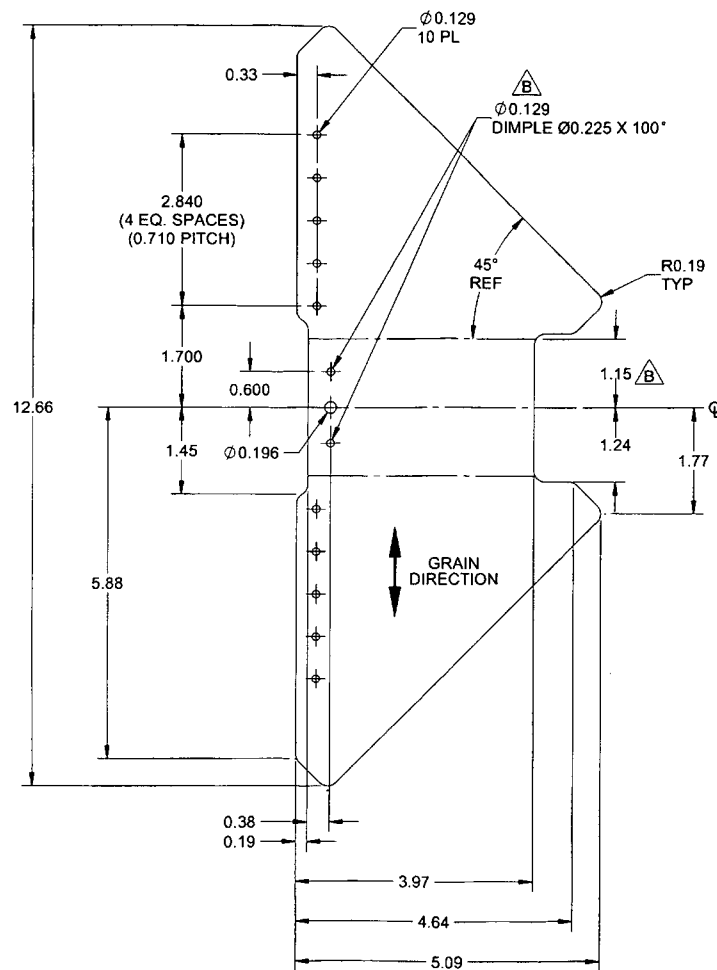
**D3531-1 BRACKET**

**RELEASED**  
12/10/13

**NOTES:**

- 1) MATERIAL: MADE FROM D3531-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | CB       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | DC       |  |              |
| CHECKED    | JS       | DRAWING NO.  | REV. B       |
| MFG. APPR. | JS       | D3531  | SHEET 2 OF 5 |
| APPROVED   | JS       | TITLE  | SCALE        |
| DE APPR.   | JS       | BRACKET ASSEMBLY   | NTS          |
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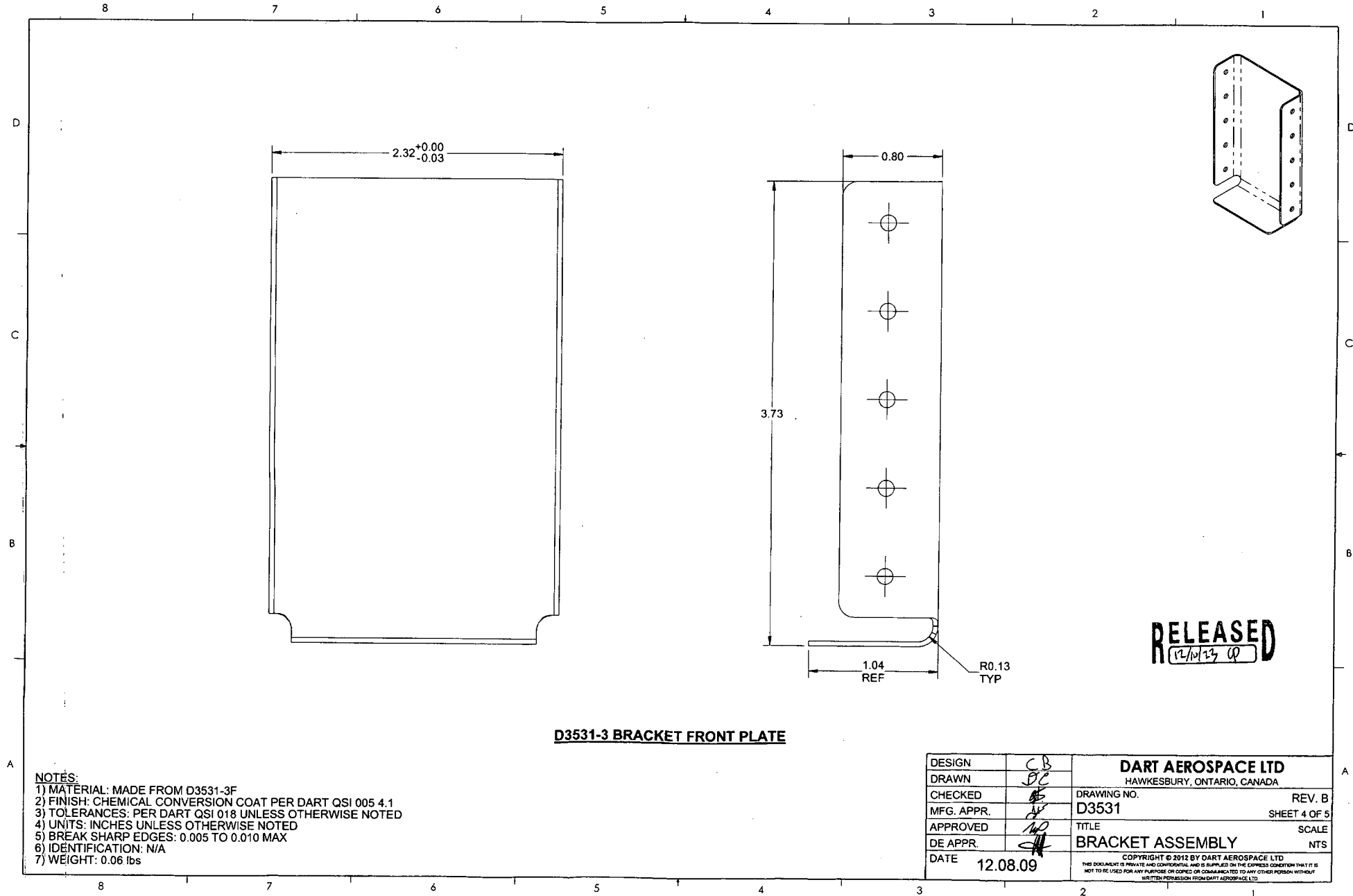
**D3531-1F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

**RELEASED**  
12/14/13

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | CB       | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | DC       | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | DC       | DRAWING NO.  | REV. B       |
| MFG. APPR. | AV       | D3531  | SHEET 3 OF 5 |
| APPROVED   | AV       | TITLE  | SCALE        |
| DE APPR.   | AV       | BRACKET ASSEMBLY   | NTS          |
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**D3531-3 BRACKET FRONT PLATE**

**NOTES:**

- 1) MATERIAL: MADE FROM D3531-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | CB       | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      | BC       | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    | BE       | DRAWING NO.   | REV. B       |
| MFG. APPR. | JE       | D3531   | SHEET 4 OF 5 |
| APPROVED   | MD       | TITLE   | SCALE        |
| DE APPR.   | JA       | BRACKET ASSEMBLY  | NTS          |
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12/10/13 CP



